Dals:

Tuesday, 4/4/2006 1:27:24 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Estimate Number

: 26495 : 10196

P.O. Number This Issue

:N/A

: 4/4/2006

: NC

: MA : 26028

S.O. No. : N/A

: MACHINED PARTS

Drawing Name

Part Number

: D21751 : D2175 REV. D.,

Drawing Number Project Number

: N/A

: ANGLE

Drawing Revision :NIA

Material **Due Date** : 4/28/2006

Qty:

20 Um:

Each

Previous Run Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

: Est E

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

2024-T3 .063 sheet

M2024T3S063 1.0

9.9162 sf(s)

2.0

Comment: Qty.: 0.4958 sf(s)/Unit Total:

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

Batch: ////903

(M2024T3S.063)

06 05 09

Comment: SHEAR

SHEAR

Cut blank: 12.75" x 2.95"

Grain along 2.95"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA083 and Dwg D2175

Stack of 10

Identify as D2175-1

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK





5.0

QC8



66-65-13

Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
<u>.</u>						i			
				. *	÷				
- · · · · · · · · · · · · · · · · · · ·		. 10		,					
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	4: <u></u>	Date:	6105/26		
			QA:	N/C Closed	d:	_ Date:			

NCR:		\	WORK ORDE	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B			A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	- Verification Section C	Approval Chief Eng	Approval QC Inspecto
			:					
			1					

NOTE: Date & initial all entries

Tuesday, 4/4/2006 1:27:24 PM Date: User: Kim Johnston **Process Sheet Drawing Name: ANGLE** Customer: CU-DAR001 Dart Helicopters Services Job Number: 26495 Part Number: D21751 Job Number: Seq. #: **Machine Or Operation:** Description: SMALL & MEDIUM FAB RESOURCE 1 6.0 SMALL FAB 1 H.M 06/05/24 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack NC BRAKE 7.0 BRAKE NC Comment: NC BRAKE Form as per Dwg D2175 INSPECT WORK TO CURRENT STEP 8.0 QC5 20 Comment: INSPECT WORK TO CURRENT STEP 9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 QC3 Comment: INSPECT CHEMICAL CONVERSION COAT 11.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ STAAO 12.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
*			4							
	()				;					
Part No	:		PAR #:	Fault Category:	NC	R: Yes	No DQ	١:	Date:	

	(2)			QA: N/0	C Closed:	Date: _		
		WORK ORDE	R NON-CONFORMAN	CE (NCR)				
		Description of NC		Corrective Action Section I	3	Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Sign &	WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Action Description Section C Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Approval Chief Eng	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26495
Description: Angle	Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: D		Page 1 of 1

	FIRS	T ARTICLE II	NSPECTI	ON CH	ECKLIST		
	2	X First Arti	cle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
12.650	+/-0.010	12.652	7		Mensuring		
R0.35	+/-0.030	RO.35	$\sqrt{}$		RADISTURG	2 .	
2.915	+/-0.010	2,918	$\sqrt{}$		vern		
50°	+/-0.010	50°	/		Protenctor		
0.300	+/-0.010	0.303	1		Vern		
1.050	+/-0.005	1.050	V		Vorn		
10.500	+/-0.005	10.502	J		Vein		
11.550	+/-0.005	11.550	V		Vern		
0.550	+/-0.010	0.553	V		Vein		
0.900	+/-0.010	0.906	J		Vern		<u>.</u>
0.063 thick	+/-0.010	0063	/		Vera		
Grain Direction	N/A		V			gaz	
					7		
	///			··			
Measured by:	1 1/11	Audited by:	4		Prototype Ap	proval:	N/A
Date: 0/	1 15 14	Date:				Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM	
				

H.S DOCUMENT $\overline{\mathbf{s}}$ Copyright © 1995 by DART AEROSPACE PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM - 12.650 R0.35 (TYP) GRAZN DERECTION 0.821 2.915 (TYP) 50° (TYP) 1.800 0.900 #0.128 (23 PLS) 0.550 -0.300 1.075 10.500 (1.050 PITCH) CHECKED 04.06.03 \Box O Œ \rightarrow -11.550 (1.050 PITCH) D2175 FLAT PATTERN 04.06.03 96.01.18 95.10.25 00.09.11 4 1.58 R0.16 DRAWING NO. D2175 1.500 ANGLE UNCONTROLLED COPY NEW ISSUE RE-DESIGN UPDATE FINISH CHANGED SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER SHOP COPY ENGINEERING NOT TO BE USED FOR DART AEROSPACE LTD. a DAR D2175-1 BEND DETAIL SHOWN DIMENSION HAWKESBURY, (D2175-2 BENT OPPOSITE) AEROSPACE I SPEC ¥ NOTES: 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES PURPOSE OR SHEET COPIED 1 OF 1 SCALE